

Date: Friday, 20/02/2009 10:49:21 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 45925		Part Number	: D2888	
Estimate Number	: 11683		Drawing Number	: D2888 REV A2	
P.O. Number	:		Project Number	: N/A	
This Issue	: 20/02/2009 S.O. No. :		Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : MACHINED PARTS		Due Date	: 27/02/2009 Qty: 10 Um: Each	
Previous Run	: 44126		Comment	: Est. C 00.06.22 Removed P/O for powder coat EC	
Written By	: <i>JL 09-02-20</i>				
Checked & Approved By	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	M6061T6B2500X03500	6061-T6 Bar 2.50 x 3.50		
		Comment: Qty.: 0.3938 f(s)/Unit Total : 3.9375 f(s) 6061-T6 Bar 2.5" x 3.5" Material: 3.5" x 2.5" bar 6061-T6	Batch <i>M110936</i>	<i>J.F. 09/03/03</i> (10)
2.0	BAND SAW	BAND SAW		
		Comment: BAND SAW Cut blanks 4.20" long (Grain along 4.20")		<i>J.F. 09/03/03</i> (10)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2888 Deburr and Tumble		<i>DTP 09/02/04</i> (10)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>DTP 09/02/04</i>	(10)
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		<i>88 09/02/26</i> (10)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>BF 09-02-26</i> (10)

Process Sheet

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



m/09996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(10)

START TIME: 10:05

OVEN TEMPERATURE: 320°

FINISH TIME: 10:35

Fx 09/03/02

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-02 (OK)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(OK)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 470

9/3/02

80

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/02 (OK)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-03

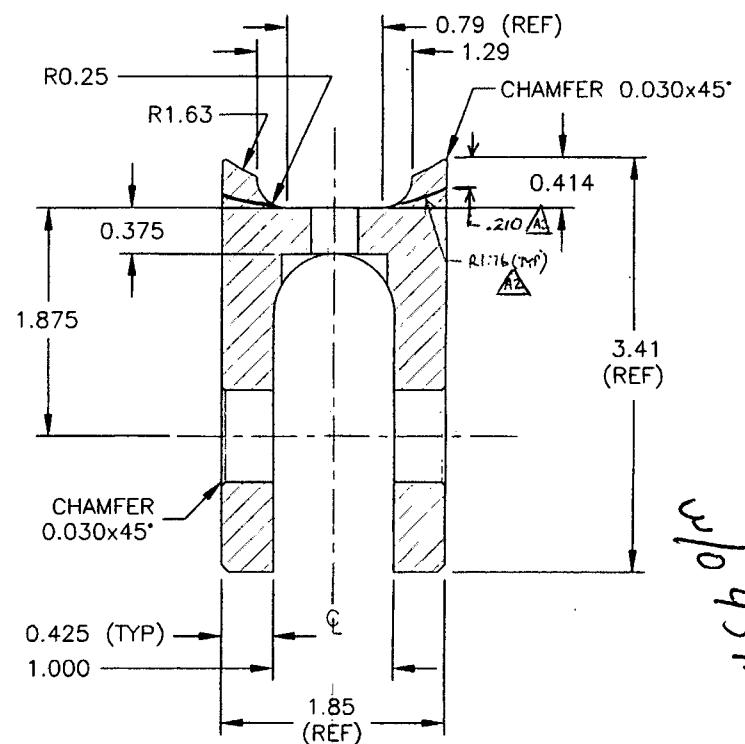
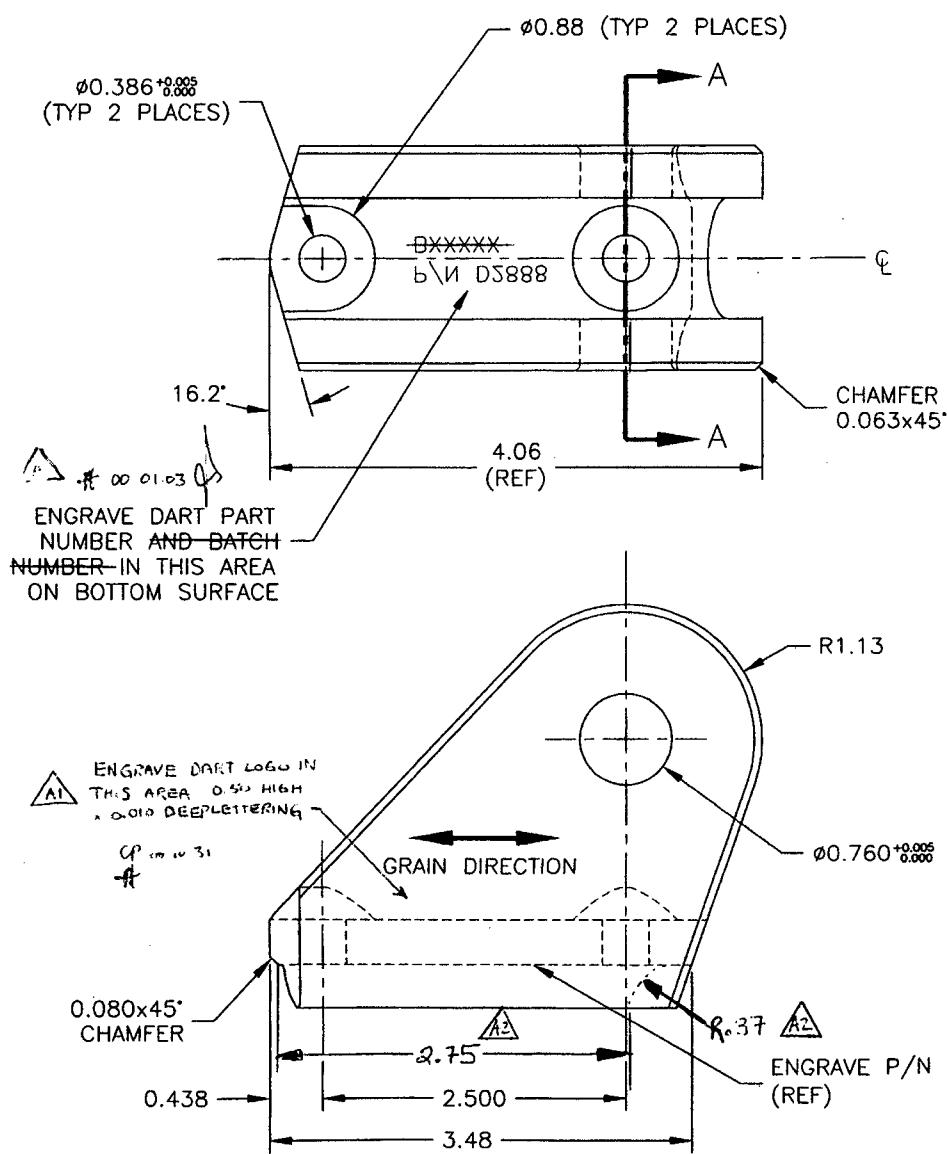
DART AEROSPACE LTD	Work Order:	45925
Description: Lug	Part Number:	D2888
Inspection Dwg: D2888 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	D.T.P	Audited by:	B.P	Prototype Approval:	N/A
Date:	09/02/24	Date:	09/02/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	



MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 BREAK UNMARKED EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 754
A1	02.10.31	Update Engineering

A	99.06.21	NEW ISSUE
DESIGN	JP	DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA
CHECKED	HE	DRAWING NO. 2888
APPROVED		REV. A
DATE	99.06.21	SHEET 1 OF 1
	LUG	SCALE 1:1